| Work Orde 1 May-28-13 8:39: | r ID 102340 | | *1 | *102340* | | | | | | | |
|--|---|--|----------------------------|---|------------|--------------|---------------------------------------|------------------|------------------|---------------------|--|
| Revision ID: Item Name: G Start Date: 5 Required Date: 5 | D3121-25 Cap 5/27/13 Start Qty: 60.00 6/31/13 Req'd Qty: 60.00 | ° *60* | Accept | *N900040100* Setup Cust Item ID: Customer: | | | | | | S1* S2* | |
| | Process Plan:QC: | Date: 13-05-79 Date: | Tooling: SPC (Y/N | | ate: | | R | tun Star Stop | 1/1 | R1* R2* | |
| Sequence ID/ Work Center ID | Operation Description | | Set Up Run H | | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp | |
| Draw Nbr | Revision Nbr | | | | | | · · · · · · · · · · · · · · · · · · · | | | | |
| D3121 | Rev E | | | | | | | | | | |
| *100 *100* Hardinge Hardinge CNC Lathe | Hardinge CNC LATH Memo Small 1-Turn D | E SMALL 3121-25 Cap as per Folio FA38 | 0.00 0.00 372-Deburr | FK 13/05/3 | 3 / | | 60 | Ğ | | , a produce parce o | |
| *110 *110* QC Quality Control | QC2- Inspect parts of Memo | f machine FAI/FAIB | 0.00 | FX 13/05/31 | | | 60 | | | | |
| *120 | QC8- Inspect parts - s | econd check | 0.00 | 3/ 13-5-3 | ı | | 60 | d | | | |
| QC Quality Control | Memo | | 0.00 | | | | | | | | |

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| | | | | | | | | | | | DQA | : Date | e: | |
|---------------|------------------------------|-------------------|-----------|-------------------|-------------------------------------|-----------------------------|-----------|-------------|------------------|-----------------|--------------------|--------------|--------------|--|
| NCR: | ⁄es | / No | | | | WORK ORDER NON- | COI | NFOR | MANCE / UP | DATE | | | | |
| | | | | | | | | | | | QA Closed | : Date | e: | |
| Work Orde | n é . | | | | | DISPOSITION | | | | AGAINST DI | DEPARTMENT/PROCESS | | | |
| WOIK OIG | ۲I. | | | | | Rework Skid-tube Crosstub | | | Crosstube | 7 | Water Jet | Engineering | | |
| Part I | VΩ | | | | | | | | Small Fab | Pro | od. Eng. Coor. | Quality | | |
| | | | Use-as-is | 1 | 1 | noforming | Finishing | -4 | ore/Packaging | Other | | | | |
| NCR No. | | | | Work Order Update | 1 | | Large Fab | Composite | 1 | Supplier | 7 | | | |
| | | | | | | | | | | | - | | | |
| Root | | | | | Descri | iption of work order update | 1 | Initial | 1 | tion | Sign & | | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Ch | nief Eng | Desc | ription | Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | | <u> </u> | | | | | | | | | | | |
| Operator | | | | | | | 1 | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Setup | _ | | | | | | | | | | | | | |
| Other | _ | | İ | | | | 1 | | | | | | | |
| Process | _ | | | | i . | | | | | | | | İ | |
| Supplier | <u> </u> | Į. | İ | ļ | , | | | | | | | | | |
| Training | <u> </u> | | | | | | | | | | | | | |
| Unapproved | L. | | | l | <u> </u> | | | TCATE | CORY | | J | <u></u> | | |
| | | | | | | | AUI | T CATE | GUKY | | | | | |
| Landing Gear | | | General | | Grain | | | Ovalized | Г | Pressure/Forced | | | | |
| | | Bend BOM/Route | \vdash | 1 | uro. | - | | r toloranco | Temperature/Cure | | | | | |
| | Centre Not Concentric to O/S | | | BOM/Route | - | Hardwa | | <u></u> | | | Weld | | | |
| | Cracks | | | proken/pamaged | roken/Damaged Inspection Incomplete | | | | Trait incom | ect | vveiu | | | |

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

| 4_ | | | | | | | | | | | |
|---|----------------------------------|---|--------------------|------------------------------|----------------------------------|-------------------|-------------|---------|---------------|------------------|----------------|
| Work Ord <i>May-28-13 8:2</i> | | 2340 | | *102 | 2340* | | | | | | Page 2 |
| Item ID: Revision ID: Item Name: Start Date: Required Date Reference: | D3121-25 Cap 5/27/13 e: 5/31/13 | Start Qty: 60.00 Req'd Qty: 60.00 | *60* *60* | ccept | *N90004 Cust Item ID: Customer: | .೧1೧(|)* | Setup S | Stop | *N: | S1* S2* |
| Approvals: | Process Pl | an: | • | Tooling: SPC (Y/N): | Date: | |] | | Start Stop | *N *N | R1* R2* |
| Sequence ID/ Work Center 130 *130* Packaging Packaging | ID | Operation Description Identify as per dwg & Sto | ck Location: 87235 | Set Up/ Run Hours 0.00 | Tool ID Too | ol # Plan Code | Accept Qty | Qty | | Reject Number | Insp. Stamp |
| 140 *140 * QC Quality Control | | QC21- Final Inspection - | Work Order Release | 0.00 | | | | 131 | 6 | J4 < | # |

MB DUB

| | | | | | | | | | | | DQA: | Date | e: |
|---------------|---------------------------|-------------|------------|----------|--------|--|--------------|----------|------------------|--|---------------------------|--------------|--------------------|
| NCR: | ⁄es | / No | | | | WORK ORDER NON-C | 100 | VFOR | MANCE / UP | DATE | | | |
| | | | · | | | , | | | | <u> </u> | QA Closed: | Date | e: |
| Work Orde | ٠ř٠ | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | |
| Part N | - No | | | | | Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite | | | 4 | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other | | |
| Root | | | | | Descri | tion of work order update | | nitial | Δς | tion | Sign & | | |
| Cause | | Date | Step | Qty | 1 | or Non-conformance | | ief Eng | | ription | Date | Verification | QC Inspector |
| Doc/Data | П | | Gtep | ~., | ` | | - | | | | | | |
| Equip/Tooling | Н | | | | | | | | | | | | |
| Operator | Н | | | | | | | | | | | | |
| Material | Н | | | | | | 1 | | | | | | |
| Setup | Н | | | | | | | | | | | | |
| Other | П | | | | | | | | | | | | |
| Process - | П | | | | | | 1 | | | | | | · · |
| Supplier | П | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | · |
| | | | _ | | | · F | AUL | T CATE | GORY | | | | |
| Landi | ng G | iear | | | | General | | _ | | | _ | _ | |
| | | Bending | | | | Bend | | Grain | | | Ovalized | | Pressure/Forced |
| | | Centre No | t Concer | ntric to | o/s | BOM/Route | | Hardwa | re | | Over/Under | tolerance | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | | Inspecti | on Incomplete | | Part Incorre | ct _ | Weld |
| | | Crushed/0 | Crimped | | | Burrs | | Instruct | ions Incomplete/ | Unclear | Part Lost/Mi | ssing | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | enance | | Part Moved | | |
| Heat Treat | | Countersink | | Mislabe | led | | Positioned V | Vrong | _ | | | | |
| | | Inspection | n Strip in | Tube | | Cut Too Short | | Misread | j . | | Power Loss/ | Surge | Other |
| | | Ripples in | Bend | | | Drill Holes | | Offset | | | | | |
| | Torque Waves in Extrusion | | | Drawing | | Out of Calibration | | | | | | | |

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Finish

Folio

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Picklist Print

May-28-13 8:39:34 AM

Work Order ID:

102340

Parent Item:

Comments:

D3121-25

Parent Item Name:

Cap

D3121

IPP Rev:A New Issue 06-05-10 JLM

IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Start Date: 5/27/13

Required Date: 5/31/13

Start Qty: 60.00

Required Qty: 60.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---------------------------------------|---------------------------------------|---------------|----------------|--------|
| MDELRINR1.2500 | | Purchased | No | | | 100 | f | 11.3000 | 0.052 | 3.284208 | | | ! |
| DELRIN ROUND BAR 1. | 25" | | | | | | | | · · · · · · · · · · · · · · · · · · · | · · · · · · · · · · · · · · · · · · · | | | |
| | | | | Location | | Loc Oty | <u>Lo</u> | c Code | | | | | |
| | | | | MAT018 | | 11.3 | | | | | • | | 1 |
| | | | | <u>ج</u> 1252 | 5 1 | 11.3 | | | | <u>,3 51</u> | 乐 | 13/05/ | 131 |

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| NCR: | Yes | / | No |
|------|-----|---|----|
| | | | |

DQA: _____ Date: ____

| NCR: Y | es / No | | | | WORK ORDER NON- | CON | FUKI | VIANCE / UPL | DATE | QA Closed: | Date | : : | |
|--|-----------------------------|-------------|---------------|-----------------|--------------------------------|--------------------|--|-------------------|----------------|--|----------------------------|---------------------|--|
| Work Orde | r: | | | | DISPOSITION | | | , <u> </u> | AGAINST D | EPARTMENT | /PROCESS | | |
| Part N | | | | | Rework Ścrap | | Skid-tube Crosstube Machining Small Fab | | | | Water Jet d. Eng. Coor. | Engineering Quality | |
| NCR N | o | | | | Use-as-is Work Order Update | ┧ ┃ | Thermoforming Finishin Large Fab Composit | | | ~ | | | |
| Root | | | | Descri | ption of work order update | ln | itial | Act | ion | Sign & | | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chie | ef Eng | Descr | ription | Date | Verification | QC Inspector | |
| oc/Data | | | | | | | | | | | | | |
| quip/Tooling | | | | | | | | | | | | | |
| perator | | | | | | | | • | | | | | |
| /laterial | _ | | | | | ŀ | | | | | | | |
| etup | _ | | | | | | | | | | | | |
| Other | _ | | | | | | | | | | | | |
| rocess | | | | | | | | | | | | | |
| upplier | - | | | | | | | | | | | | |
| raining | - 1 | | | | | | | | | | | | |
| Inapproved | | <u>.</u> | L | | | ΔΗΤ | CATE | GORY | | | | | |
| Landin | g Gear | | | | General | AOLI | CATE | <u> </u> | | | | | |
| [| Bending | | | | Bend | \Box | Grain | | Г | Ovalized | Г | Pressure/Forced | |
| ľ | ⊣ ` | lot Conce | ntric to | o/s | BOM/Route | \vdash | Hardwa | re . | <u> </u> | Over/Under | tolerance | Temperature/Cure | |
| ŀ | Cracks | | | | Broken/Damaged | | | on Incomplete | <u> </u> | Part Incorre | - | Weld | |
| Ì | | /Crimped | | | Burrs | \vdash | • | ions Incomplete/L | Jnclear - | Part Lost/Mi | ssing | Wrong Stock Pulled | |
| 1 | Cuffs | • | | | Contamination | - | Mainte | | <u> </u> | Part Moved | _ | _ | |
| ŀ | Heat Treat Countersink | | \sqcap | Mislabe | led | Γ | Positioned V | Vrong | | | | | |
| Inspection Strip in Tube Cut Too Short | | | Cut Too Short | \square | Misread | l | <u> </u> | Power Loss/ | Surge Γ | Other | | | |
| | Ripples in Bend Drill Holes | | | Offset | | | | | | | | | |
| | Torque ' | Waves in I | Extrusio | , | Drawing | Out of Calibration | | | | | | | |
| | Turning Sequence Finish | | | Out of Sequence | | | | | | | | | |
| Ī | | | Folio | П | Outside Dimensions | | | | | | | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| DART AEROSPACE LTD | Work Order: | 102340 |
|------------------------------|--------------|-------------|
| Description: Cap | Part Number: | D3121-25 |
| Inspection Dwg: D3121 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|---------------------|--------|--------|-------------------------|---------------------------------------|
| 0.315 | +/-0.010 | ,318 | 7 | | FK-04 | Vern. |
| Ø1.000 | +/-0.010 | 1.000 | 7 | | 11 | h |
| Ø0.838 | +/-0.002 | .8375 | 7 | | " | 1, |
| R0.063 | +/-0.010 | . 063 | 7 | | h | 4 |
| R0.010 | +/-0.010 | .015 | 7 | | " | 9 |
| 0.230 | +/-0.001 | •230 | 7 | | 4 | 4 |
| Ø0.865 | +/-0.001 | 208. | | | 7) | . |
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| | | | | | | |

| Measured by: | F-K- | Audited by: | Prototype Approva | : N/A |
|--------------|----------|---------------|-------------------|-------|
| Date: | 13/05/31 | Date: / 3 · g | -31 Date | : N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|---|
| Α | 04.04.20 | New Issue (P/O D3121-241) | KJ/RF | · • • · · · · · · · · · · · · · · · · · |
| В | 06.06.09 | Ø1.000 diameter was Ø1.024 | KJ/JLM | |
| С. | 08.01.16 | Dwg Rev. updated | KJ/EC/DD | 13/ |
| | | | . () | |



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| # 0 | | LE LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|------|------|----------|---|
| CHEC | KED | APPROVED | DRAWING NO. REV. E |
| | 91 | M | D3121 SHEET 1 OF 10 |
| DATE | | | TITLE SCALE |
| 07.1 | 1.07 | | BRACKET ASSEMBLY 1:2 |
| Α | | 02.04.15 | NEW ISSUE |
| В | | 03.01.16 | ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146 |
| С | | 04.02.17 | ADD CLEARANCE; USE -241 BEARING |
| D | | 06.05.17 | D3121-25 CAP WAS 1.024, NOW 1.000 |
| Ε | | 07.11.07 | ADD TOLERANCE TO 0.032 (DETAIL B) |

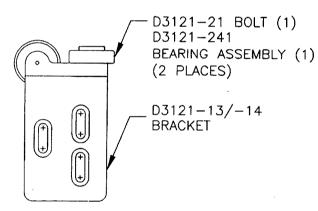


| - D3121-2 | 21 BOLT (1 |) |
|-----------|------------|-----|
| D3121-2 | 241 | • |
| BEARING | ASSEMBLY | (1) |

D3121-041 BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-33)

D3121-11 BRACKET



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-37/-38)

D3121-21 BOLT (1) D3121-241 BEARING ASSEMBLY (1) (2 PLACES)

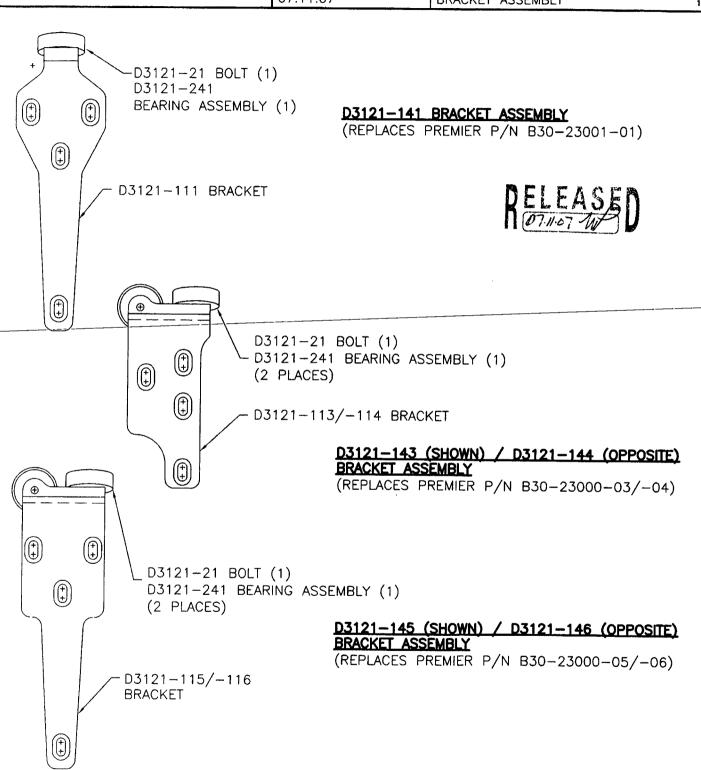
D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)

D3121-15/-16 BRACKET



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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| 4# | | D3121 | SHEET 2 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |

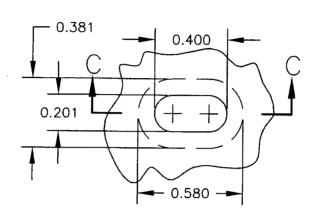


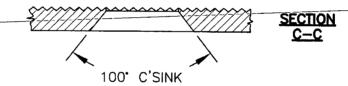
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| # | - | D3121 | SHEET 3 OF 10 |
| DATE | | ΠΠLΕ | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:1 |



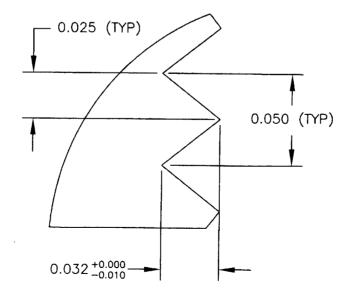






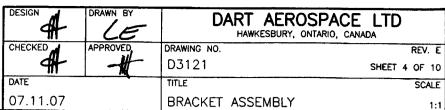
DETAIL B: RIDGE DETAIL PARTIAL SECTION

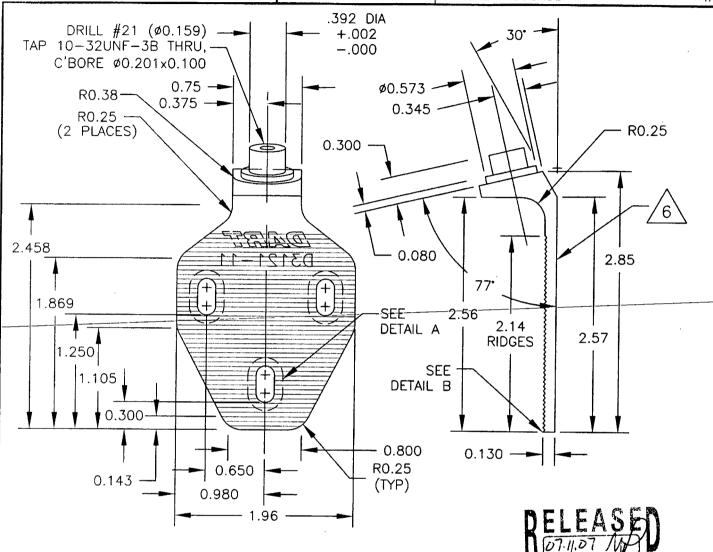
SCALE 1:20



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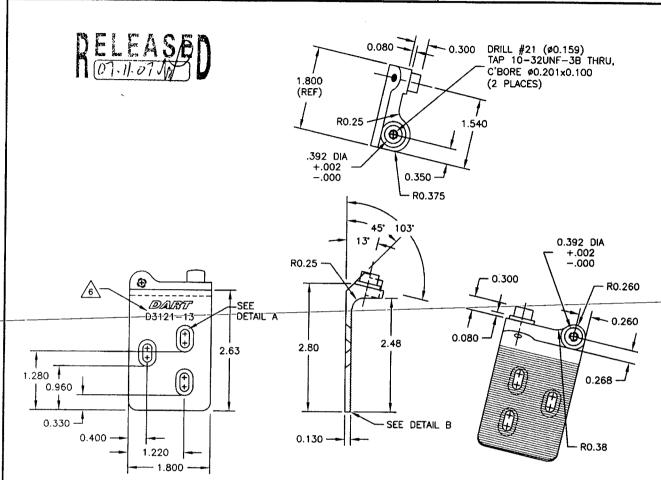
D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| 4 | -# | D3121 | SHEET 5 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



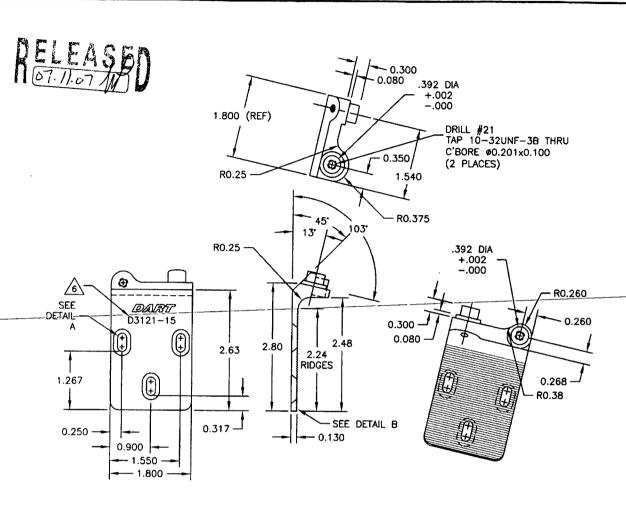
D3121-13 BRACKET (SHOWN) D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi
 MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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| 94 | | D3121 | SHEET 6 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



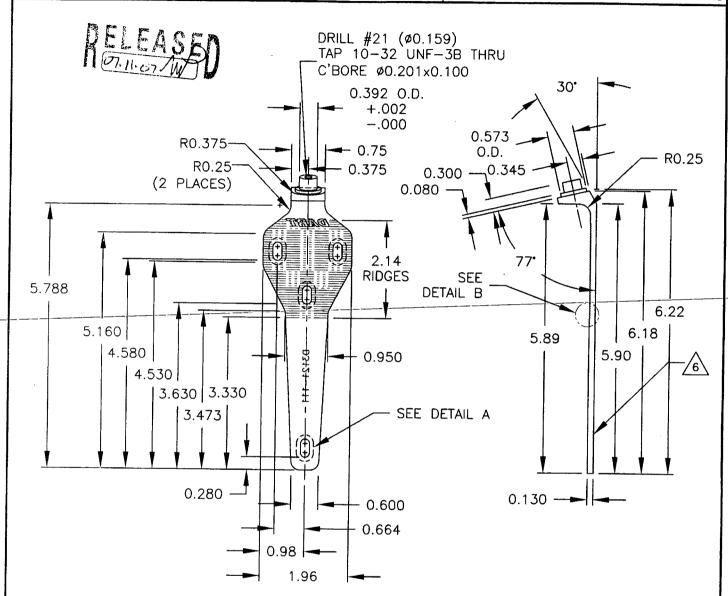
D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi
 - MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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|----------|----------|--|---------------|
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| 44 | | D3121 | SHEET 7 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



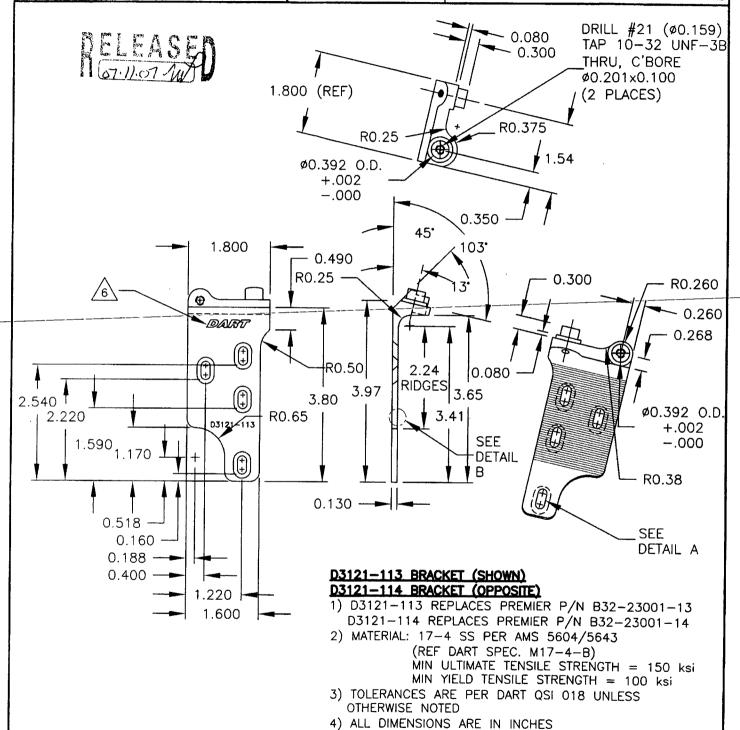
D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi
 - MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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| DESIGN # | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|----------|----------|--|---------------|
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| 911 | | D3121 | SHEET 8 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |

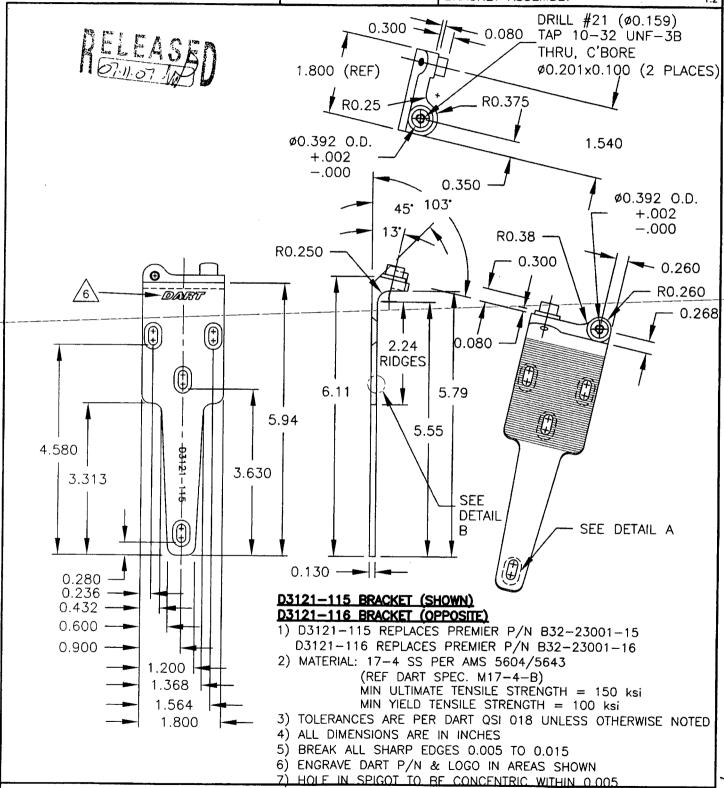


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5) BREAK ALL SHARP EDGES 0.005 TO 0.015 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

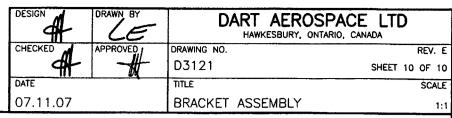


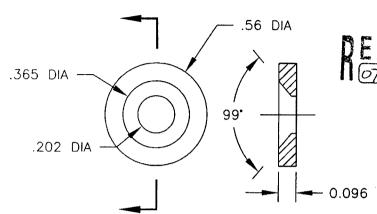
| DESIGN # | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|----------|-----------|--|---------------|
| CHECKED | APPROVED, | DRAWING NO. | REV. E |
| 771 | | | SHEET 9 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



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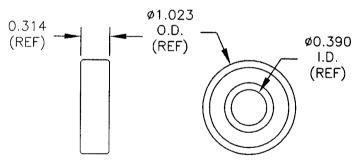






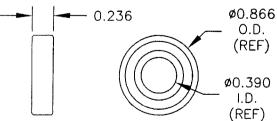
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



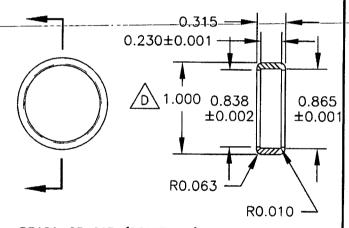
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

0.375 TAP 10-32 UNF-3A PELEASE 0.080 0.050 TO 0.060

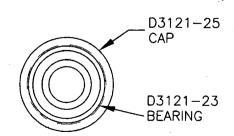
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25
 - (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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